

Date: Tuesday, 7/17/2007 2:01:14 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY	
Job Number	: 33597				
Estimate Number	: 11641				
P.O. Number	: N/A		Part Number	: D2990042	
This Issue	: 7/17/2007		S.O. No.	: N/A	
Prsh Rev.	: NC		Drawing Number	: D2990 REV B	
First Issue	: N/A		Project Number	: N/A	
Previous Run	: N/A		Drawing Revision	: B	
Written By			Material	: N/A	
Checked & Approved By			Due Date	: 8/10/2007	
Comment	Est	B	Qty:	7	Um: Each
05.02.22 Revised Step 6 KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D28052	Stop			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s) STOP Pick: Qty Part Number 1 D2805-2 Description Stop Batch B29406 <i>B 33600/B34033 x2</i> <i>ml</i> <i>B29406 x 5 myv</i>					
2.0	D29902	Bracket			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s) Bracket Pick: Qty Part Number 1 D2990-2 Description Bracket Batch <i>B 33602 x 5 ✓</i> <i>(B 33600/B34033) x2</i> <i>ml</i>					
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2805-2 into arm as per Dwg D2990 <i>ml 07/08/27 x 7</i> <i>mf 07-08-</i>					
4.0	QC5	INSPECT WORK TO CURRENT STEP			
Comment: INSPECT WORK TO CURRENT STEP <i>Ex 07/08/28 (x)</i>					
5.0	POWDER COATING	POWDER COATING			
Comment: POWDER COATING Powder Coat Green Sandtex (Ref. 4.3.5.8) as per QSI 005 4.3 <i>M-f 07/08/29</i>					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 2:01:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 33597

Part Number: D2990042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



1/8/2959

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	M102552

S9

8.0

MS210426-3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS210426-3	Nut	M10936

M105211*

1/8/2959

9.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	M105164

A/R LPS-3

Corrosion Spray

M104929

1/8/2959

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2990
Assemble as per Dwg D2990.

M107108/2959

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1/8/2959

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/08/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

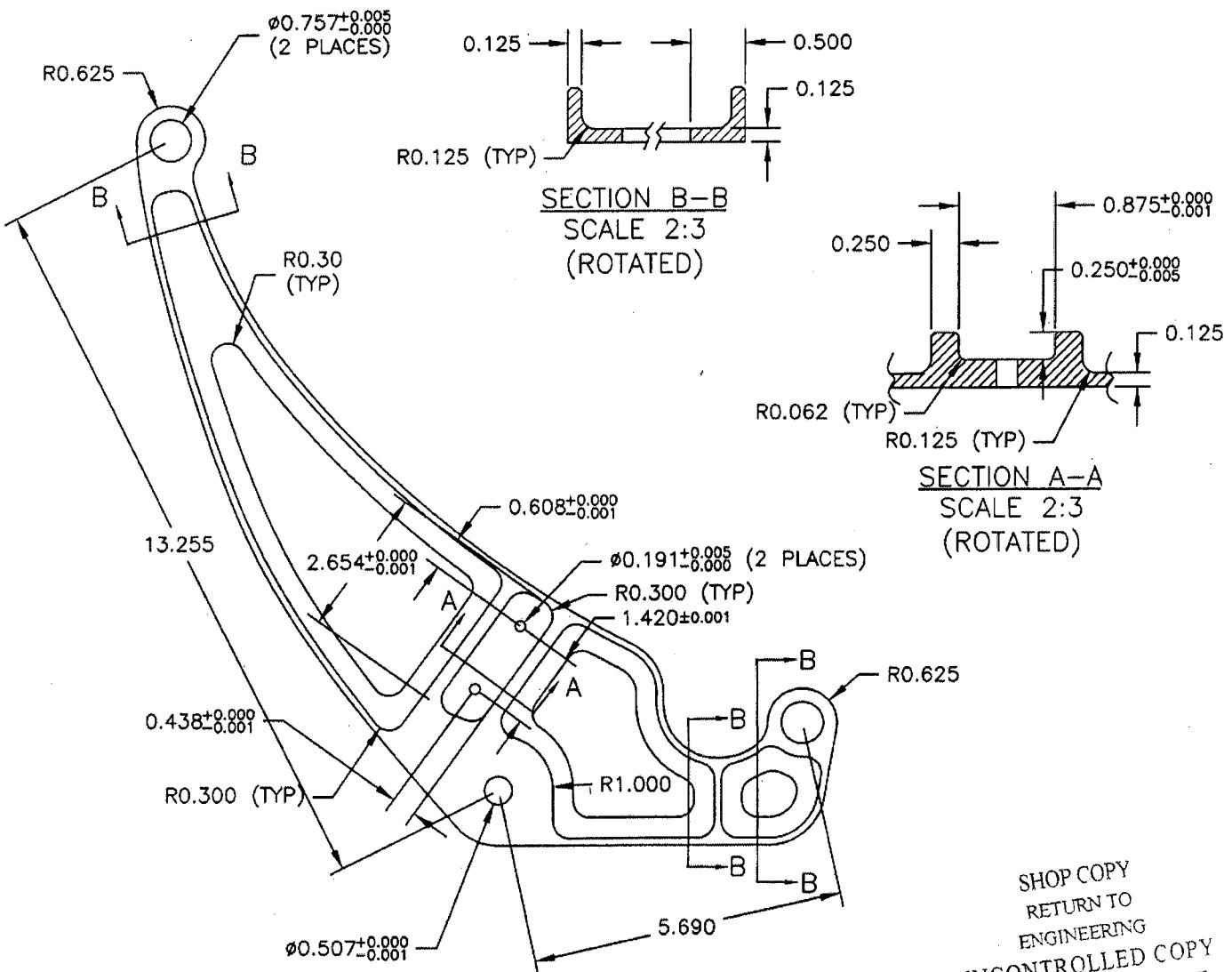
DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2990
DATE 05.01.20	TITLE STA 129 BRACKET	SCALE 1:3

REV. B
SHEET 1 OF 2

RELEASED

05.03.11 *[initials]*

A	00.11.07	NEW ISSUE
B	05.01.20	ADD CUTOUTS & -043/-044



D2990-1 BRACKET (SHOWN), D2990-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2990.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

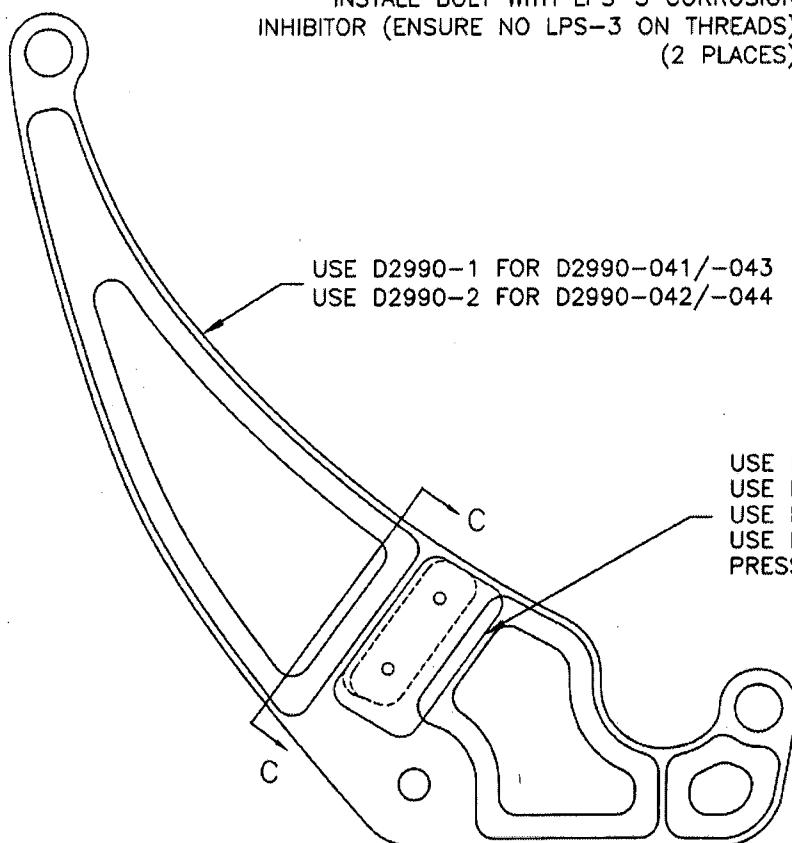
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33597



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2990
DATE 05.01.21		REV. B SHEET 2 OF 2 TITLE STA 129 BRACKET SCALE 1:3

RELEASED

05.03.11 *[initials]*



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2805-1 FOR D2990-041
USE D2805-2 FOR D2990-042
USE D2805-3 FOR D2990-043
USE D2805-4 FOR D2990-044
PRESS INTO PLACE PRIOR TO POWDER COAT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *33597*

D2990-041/-043 BRACKET ASS'Y (SHOWN)
D2990-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3